

28

Date: Wednesday, 6/6/2007 1:45:20 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (19"X24")
Job Number	: 32768		
Estimate Number	: 10323		
P.O. Number	: N/A	Part Number	: D206559013
This Issue	: 6/6/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2432 REV F3
First Issue	: N/A	Project Number	: N/A
Previous Run	: 32012	Drawing Revision	: F3
		Material	: N/A
		Due Date	: 7/10/2007
Written By	: <u>[Signature]</u>	Qty:	10 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev:J 04.02.17 Blank size changed KJ/JLM Est Rev:K 07-01-02 Was K10008 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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KS 07.06.14

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-013 CHG005

S A 10/23

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 6.8250 sf(s)/Unit Total : 68.2500 sf(s)  
 blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5  
 Material: Black UHMW 1" (MUHMWB10) M105862X14  
 Batch: M105-863 X 6 J.F. 07/10/18

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

J.F. 07/10/20

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 07/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: BEARPAW KIT (19"X24")

Job Number: 32768

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 07/10/21 (20)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 2.5000 f(s)/Unit Total : 25.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion B30812 AS

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block B 32015 DS

2 D2432F(ref only) Bearpaw 32768

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp B 33937 AS

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch


12 D2529 Washer B30382 AS

B32025 DS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: BEARPAW KIT (19"X24")

Job Number: 32768

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

HH  
HH  
S  
(10)

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4166 f(s)/Unit Total : 4.1660 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion B34717 AS

HH  
HH  
S  
(10)\*

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

M104072

(27X)

M104764

(93 X)

HH  
HH  
S  
(10)

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M103691

AS

HH  
HH  
S  
(10)

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M105426

AS

HH  
HH  
S  
(10)

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M104683

AS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 9/18/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:45:20 PM  
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Job Number: 32768

Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5/2/0/23 (10)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-013

Location: A

5/10/23 (10)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

5/10/23 (10)

Job Completion



5/10.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32768
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2432
<b>Inspection Dwg:</b> D2432 <b>Rev:</b> F3		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.055x45°	✓			
B	5.500	+/-0.030	5.501	✓			
C	0.200	+/-0.030	0.203	✓			
D	0.25 x 45°	+/-0.030	0.249x45°	✓			
E	R0.250	+/-0.030	R0.250	✓			
F	0.250	+/-0.010	0.243	✓			
G	0.625	+/-0.030	0.610	✓			
H	0.375	+/-0.010	0.384	✓			
I	0.950	+0.030/0.010	0.947	✓			
J	19.000	+/-0.030	19.000	✓			
K	3.14	+/-0.030	3.110	✓			
L	3.28	+/-0.030	3.310	✓			
M	Ø0.260	+0.005/-0.000	Ø0.266	✓			
N	Ø0.93	+/-0.030	Ø0.927	✓			
O	0.30	+0.030/-0.000	0.310	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	2.000	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	0.380	✓			

<b>Measured by:</b>	<i>ml</i>	<b>Audited by:</b>	J.L	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07/10/19	<b>Date:</b>	07/10/19	<b>Date:</b>	

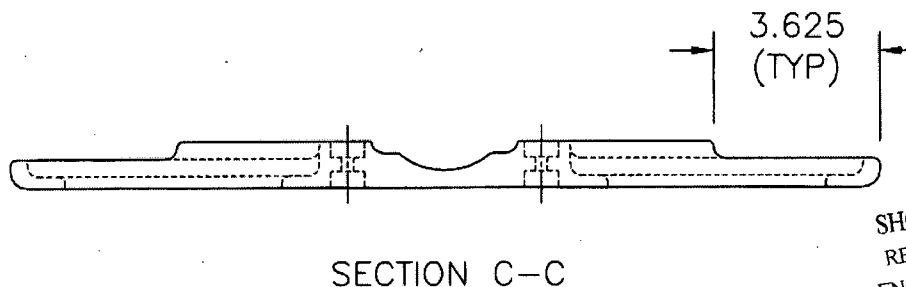
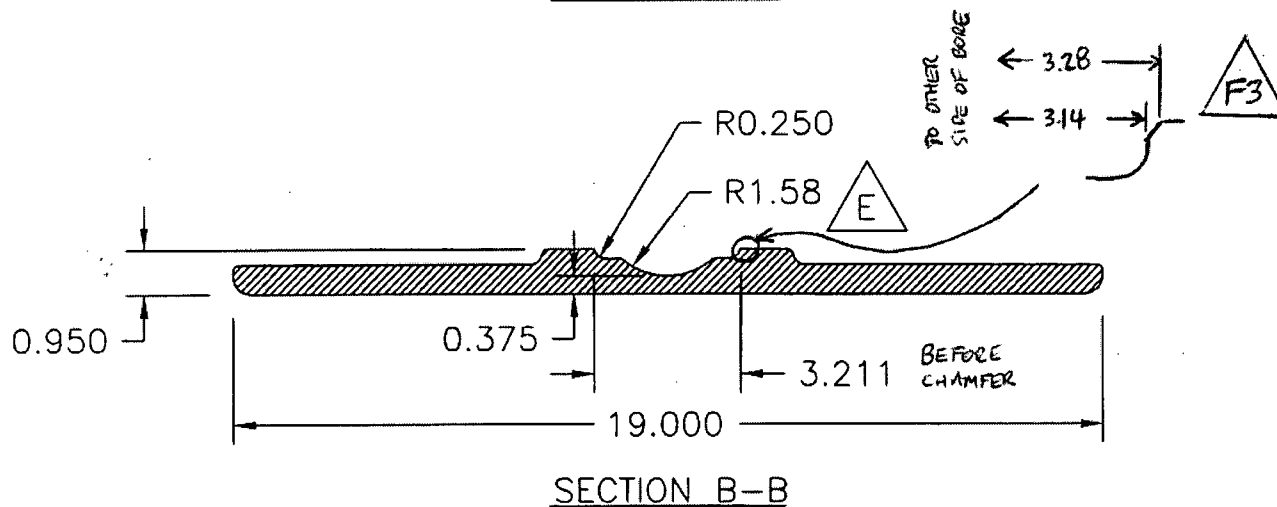
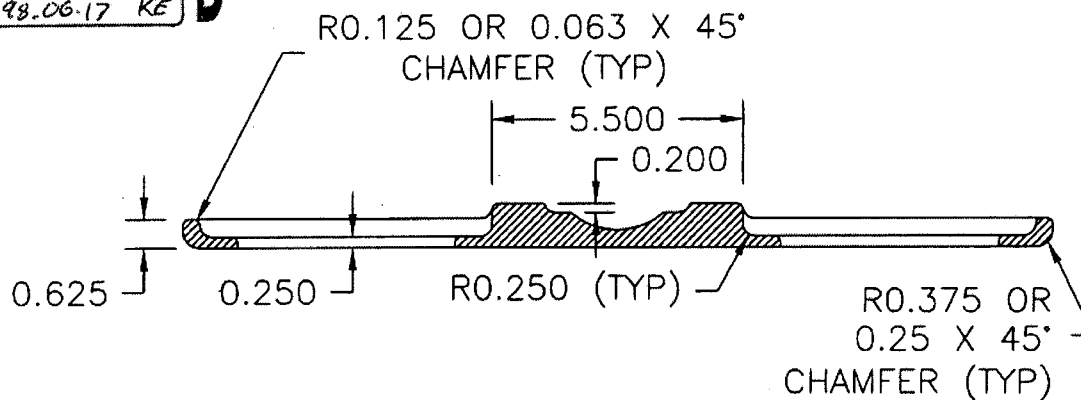
Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue      P/O K10008/D206-559-015	KJ/RF <i>af</i>	<i>#</i>





DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED  
98.06.17 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30768

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D206-559

Job Number : 36674

Estimate Number : 10804

P.O. Number : N/A

This Issue : 09/01/2008 S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A Type : MACHINED PARTS

Previous Run : 00015

Part Number : Z\_CUSTOM

Drawing Number : ECN1101

Project Number : N/A

Drawing Revision : N/A

Material : N/A

Due Date : 16/01/2008

Qty: 1 Um: Each

Written By : W  
Checked & Approved By : W  
Comment :

#### Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK:

D206-559-011

B34288 (10x) B30377 (x2) B30800 (x1) B32977 (x5)

D206-559-013

B32728 (9x) B30340 (2x)

D206-559-021

B28342 (x4)

D206-559-023

B25291 (x3) B34856 (x5)

D206-559-025

B28731 (x4)

ADD NEW PAPERWORK JCAB STC: STC-90-TYO  
PER ECN 1101

RETURN TO STK

8/1/10 SD 45x AS

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20810111

Job Completion



W 28-01-11

**CUSTOMER RETURN**

#R08-D15

**Initiator:** D. Trepanier  
**Company:** Hill Aircraft (Air Logistics)  
**Phone No.:** \_\_\_\_\_  
**Date:** FEB 27/06  
**Invoice #** 5839  
**Order Entry #** 5383

**Attach Copy of DHS Return Authorization #** \_\_\_\_\_

**Reason for return:** NCR08-020  
Air Logistics received this order

**Receiving:** 8/3/03  
**Date Received:** 8/3/03 **Freight Company:** FedEx **Prepaid** ☐ **Collect** ☐

#	Part #	Batch #	Description	Distribute to QC	
				Advise QA	Date:
1	D206-559-013	32768	Bar-faws	<u>DATE</u>	<u>8/3/04</u>

**Condition of packaging:** Good **Photograph required:** yes ☐ no ☒

**Paperwork attached:** P/S ☒ **Invoice** \_\_\_\_\_ **ARC** \_\_\_\_\_ **Docs** \_\_\_\_\_ **Other** \_\_\_\_\_

**QC:**  
**Quarantine:** **Location:** \_\_\_\_\_ **Condition of Part:** excellent  
**Inspect:** **Initial:** [Signature]

#	Part #	Batch #	QC Comments	QC Approval		Scrap
				Initial	W/O #	
1	D206-559-013	32768	Return to stock as per W/O.	<u>[Signature]</u>	<u>38119</u>	

**QA Coordinator:**  
**Advise GM as to findings:** **Initial:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Comments:**  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_  
 \_\_\_\_\_

**Issue credit:** yes ☐ no ☐  
**GM Approval:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Invoice Amount:** \_\_\_\_\_  
**Less Replacement:** \_\_\_\_\_  
**Restock Fee:** \_\_\_\_\_  
**Freight:** \_\_\_\_\_  
**Net Credit:** \_\_\_\_\_  
**DHS** ☐ **Customer** ☐

**QA:** Enter into Q-Pulse with reason for return & File original. **Signed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit